

Work Order ID 158816

Friday, March 31, 2017 7:24:17 PM

158816

Page 1

Item ID: D2573 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Aft, Out
Start Date: 3/31/2017 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 4/12/2017 Req'd Qty: 12.00 ***12*** Customer:
Reference: SCHEDULED

Approvals: Process Plan: _____ Date: MAR 31 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2573	F

100

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Program Batch No. 158816Double check by: mark

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

2.21

8.84

12

DAS

44

9-89 17-04-08

DAS

45 17-04-10

9-89

110

110

Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

Machine keyway as per dwg D2573 & D2574

0.00

1.08

12

DAS

44

9-89 17-04-08

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.12				<u>12</u>			DAS 44 9-89 17-04-09 DAS 45 17-4-10 9-89
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.24				<u>12</u>	<u>0</u>		DAS 33 9-89 17/04/12
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 1.03				<u>(X12)</u>	<u>0</u>		2017/04/20 BEB

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Item ID: D2573 Accept ***N900040100*** Setup Start ***NS1***
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Required Date: 4/12/2017 Req'd Qty: 12.00 ***12*** Customer:
Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 136657</i> Memo START TIME: <i>2:00</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>2:30</i>	0.00 0.24				<i>12</i>	<i>0</i>	<i>1704-20.</i>	<i>DAS 34 9-89</i>
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.12				<i>12</i>			<i>DAS 38 9-89</i> <i>APR 21 2017</i>
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <i>ST398</i> Memo	0.00 0.12				<i>12x</i>		<i>8017-4-24</i>	

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Item ID: D2573 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Saddle, Aft, Out
Start Date: 3/31/2017 Start Qty: 12.00 *12* Cust Item ID:
Required Date: 4/12/2017 Req'd Qty: 12.00 *12* Customer:
Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21 - Final Inspection - Work Order Release	0.00							
180									
QC	Memo	1.20							
Quality Control									

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9-89

APR 25 2017

Picklist Print

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Work Order ID: 158816

158816

Parent Item: D2573

D2573

Parent Item Name: Saddle, Aft, Out

Start Date: 3/31/2017

Required Date: 4/12/2017

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: I As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	24.0000	1	12			

D6101-007

Saddle Billet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT041	24	
154453	4	
156737	20	

DAS
14
9-89

17/04/07

DART AEROSPACE LTD		Work Order: 178816
Description: Saddle, Aft Outboard		Part Number: D2573
Inspection Dwg: D2573 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	0.500	0.501	0.501		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.502	0.499	0.500	0.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.570	0.565	0.565	0.565		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.130	.130	.130	.130		
Q	0.115	0.135		.121	0.127	0.127	0.127		
R	0.240	0.260		.254	0.253	0.254	0.253		
S	0.115	0.135		.125	0.125	0.129	0.129		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.231	3.230	3.230	3.230		
V	0.230	0.250		.241	0.235	0.237	0.236		
W	0.115	0.135		.121	0.121	0.121	0.121		
X	0.308	0.313		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.762	0.762	0.762	0.762		
Z	0.352	0.372		.364	0.364	0.364	0.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.629	0.625	0.625	0.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.251	0.248	0.250	0.250		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.265	.265	.265	.265		
AH	0.240	0.260		.247	0.247	0.248	0.248		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

DAS
45

DAS

Measured by: 44	9-89
Date: 17-04-09	17-4-10

Audited by: 33	9-89
Date: 17/04/12	

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 158816
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5 18	6 29	7 10	8 18		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.500	0.499	0.500	0.500		
G	0.257	0.262		0.257	0.257	0.257	0.257		
H	0.375	0.380		0.377	0.377	0.377	0.377		
I	0.490	0.510		0.501	0.498	0.496	0.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.567	0.564	0.561	0.564		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.134	0.134	0.134	0.134		
Q	0.115	0.135		0.125	0.125	0.125	0.126		
R	0.240	0.260		0.253	0.253	0.253	0.253		
S	0.115	0.135		0.127	0.125	0.125	0.128		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.239	0.240	0.240	0.238		
W	0.115	0.135		0.122	0.123	0.124	0.123		
X	0.308	0.313		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.762	0.762	0.762	0.762		
Z	0.352	0.372		0.364	0.364	0.364	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.626	0.626	0.626		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.251	0.252	0.252	0.253		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		0.125	0.125	0.125	0.125		
AG	0.240	0.280		0.265	0.265	0.265	0.265		
AH	0.240	0.260		0.249	0.249	0.246	0.248		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		

Accept/Reject

DAS

Measured by: 9-8	Audited by: 33
Date: 17-4-10	Date: 9-89 17/04/12

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 158816
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	94	102	118	124		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.501	0.499	0.500	0.499		
G	0.257	0.262		0.257	0.257	0.257	0.257		
H	0.375	0.380		0.377	0.377	0.377	0.377		
I	0.490	0.510		0.500	0.497	0.500	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.563	0.561	0.564	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.134	0.134	0.134	0.134		
Q	0.115	0.135		0.128	0.126	0.125	0.125		
R	0.240	0.260		0.253	0.253	0.253	0.253		
S	0.115	0.135		0.123	0.125	0.125	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.240	0.241	0.241	0.238		
W	0.115	0.135		0.123	0.124	0.124	0.125		
X	0.308	0.313		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.762	0.760	0.760	0.760		
Z	0.352	0.372		0.364	0.364	0.364	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.626	0.626	0.626		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.251	0.251	0.251	0.251		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		0.125	0.125	0.125	0.125		
AG	0.240	0.280		0.265	0.265	0.265	0.265		
AH	0.240	0.260		0.247	0.248	0.248	0.248		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		

Accept/Reject

DAS

Measured by:	9-89
Date:	17-4-10

Audited by:	33
Date:	9-89 17/04/12

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	